

Work Order ID 115476

April-02-14 10:08:37 AM

Ship April 11

115476

Page 1

Item ID: D3562-042

Accept

N900040100

Setup

Start *NS1*

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-04-02

Tooling:

Date:

Run

Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3562 | F |

100 *100* Large Fab
Large Fab
Large Fab
Memeo
1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

i 6 K.D.C
14-04-02

110 *110* QC6- Inspect dimensions to drawing 0.00
QC
Quality Control
Memeo
0.00

① 14-04-04 DAS
9-00

120 *120* HandFinish Chemical Conversion Coat per QSI005 4.1 0.00
Hand Finishing
Memeo
0.00

DC
14-04-04
RJ.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____

DISPOSITION

Part No. _____

Rework

NCR No. _____

Scrap Use-as-is Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Folio/Program | Outside Dimensions | Pressure/Forced |
|--------------------------|----------------------|-----------------------------------|----------------------|--------------------|
| Bending | Bend | Grain | Over/Under tolerance | Set-up |
| Centre Not Concentric | BOM/Route | Hardware | Part Incorrect | Temperature/Cure |
| Cracks | Broken/Damage/Defect | Inspection Incomplete/Unqualified | Part Lost/Missing | Weld |
| Crimp/Kink/Ripple/Wave | Burrs | Instructions Incomplete/Unclear | Part Moved | Wrong Stock Pulled |
| Cuffs | Contamination | Misaligned/off center | Positioned Wrong | |
| Crushing | Countersink | Mislabeled | Power Loss/Surge | Other |
| Heat Treat | Cut Too Short | Misread | | |
| Inspection Strip in Tube | Drawing | Off-set | | |
| Marks/Chatter | Drill Holes | Out of Calibration | | |
| Turning Sequence | Finish | Out of Sequence | | |
| Wave/Twist in Tube | Fit/Function | | | |

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Page 2

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool

ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Quality Control

1

8

K
14-04-07

140

Small Fab

0.00

140

Small Fab

Small Fab

Memo

0.00

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Scotch-Weld DP460

Batch: 126003 EXP DATE: 14-05-01

1

8

K
14-04-07

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--------------------------|----------------------|------|--|--|--|--|---------------------------------|--------------|--------------|--|--|
| | | | Rework Scrap Use-as-is Suspected Unapproved | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Design | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Transport | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | General | | | | | | | | |
| Bending | Bend | | Folio/Program | | Outside Dimensions | | Pressure/Forced | | | | |
| Centre Not Concentric | BOM/Route | | Grain | | Over/Under tolerance | | Set-up | | | | |
| Cracks | Broken/Damage/Defect | | Hardware | | Part Incorrect | | Temperature/Cure | | | | |
| Crimp/Kink/Ripple/Wave | Burrs | | Inspection Incomplete/Unqualified | | Part Lost/Missing | | Weld | | | | |
| Cuffs | Contamination | | Instructions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled | | | | |
| Crushing | Countersink | | Misaligned/off center | | Positioned Wrong | | | | | | |
| Heat Treat | Cut Too Short | | Mislabeled | | Power Loss/Surge | | | | | | |
| Inspection Strip in Tube | Drawing | | Misread | | | | | | | | |
| Marks/Chatter | Drill Holes | | Off-set | | | | | | | | |
| Turning Sequence | Finish | | Out of Calibration | | | | | | | | |
| Wave/Twist in Tube | Fit/Function | | Out of Sequence | | | | | | | | |

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Page 3

Item ID: D3562-042

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 1.00

1

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|------|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | Stop | | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|------------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 *150* QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | DAS 9 |

Quality Control

① 140407

160

160

Large Fab

Large Fab

Memo

0.00

1

140408

Large Fab

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod 125/27

2-Grind end cap welds flush as per Dwg D3562

170

170

QC

QC10- Inspect visual per QSI004- ground welds

0.00

①

140409

DAS

9

9.89

Quality Control

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

| Work Order: _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|------|-----|--|--|------------------------------------|--|---|-------------|--------------|--------------|
| | | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| | | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Design | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Transport | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | | | |
| | | | | | | | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/> | | | |
| | | | | | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | |

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

| | | |
|---|--|---|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
|---|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|--|--|---|--|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|--|

Work Order ID 115476

April-02-14 10:08:37 AM

115476

Page 5

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|-------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | | | | | | Stop | *NR2* |
| | QC: | Date: | SPC (Y/N): | Date: | | | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|-------------|-------------------|---------------|---------------|------------------|----------------|
| 210 *210* HandFinish | Wing Walk as per dwg QSI005 4.4 Batch <u>128623</u> | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| 220 *220* QC | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| 230 *230* Packaging | Identify as per dwg & Stock Location: _____ | 0.00 | Ship | APR 09 2014 | DAS 06 9-63 | | | | |
| | Memo | 0.00 | | | | | | | |

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

| | | | | | |
|---|--|---|--|--|--|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved | AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab | <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite | <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier | <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other |
|---|--|---|--|--|--|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | | | | | | | | | | | |
|--|--|--------------------------|--------------------------|--------------------------|---|--------------------------|--------------------------|--------------------------|--|--------------------------|--------------------------|--------------------------|--|--------------------------|--------------------------|--------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | | | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

| | | |
|---|--|---|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
|---|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | |
|--------------------------|--------------------------|----------------------|--------------------------|-----------------------------------|--------------------------|----------------------|--------------------------|--------------------|--------------------------|
| Landing Gear | | | | | General | | | | |
| Bending | <input type="checkbox"/> | Bend | <input type="checkbox"/> | Folio/Program | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | Pressure/Forced | <input type="checkbox"/> |
| Centre Not Concentric | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Set-up | <input type="checkbox"/> |
| Cracks | <input type="checkbox"/> | Broken/Damage/Defect | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Temperature/Cure | <input type="checkbox"/> |
| Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Burrs | <input type="checkbox"/> | Inspection Incomplete/Unqualified | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Weld | <input type="checkbox"/> |
| Cuffs | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | Wrong Stock Pulled | <input type="checkbox"/> |
| Crushing | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | Other | <input type="checkbox"/> |
| Heat Treat | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Power Loss/Surge | <input type="checkbox"/> | | |
| Inspection Strip in Tube | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Misread | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| Marks/Chatter | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Off-set | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| Turning Sequence | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| Wave/Twist in Tube | <input type="checkbox"/> | Fit/Function | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | | <input type="checkbox"/> | | |

Picklist Print

Page 1

April-02-14 10:08:40 AM

Work Order ID: 115476

115476
D3562-042

Parent Item: D3562-042

Parent Item Name: Step Weldment

Start Date: 4/02/14

Required Date: 4/11/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

| | | | |
|--|-----------|----------|--------------------|
| IPP Rev:A | New Issue | 06-11-09 | JLM |
| IPP rev B | ECN 987 | 07.10.09 | EC verified by: DD |
| IPP Rev:C | ECN1048 | 07-12-18 | DD verified by: EC |
| IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E | | | |
| 13.06.03 PER DWG REV.F DD VERF:JLM | | | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C | | Manufactured | No | | | 100 | Each | 114.0000 | 1 | 1 | | 14-04-07 | ** |
| *D2622-120C* Step Extrusion | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL | 112 | |
| WA003 | 112 | |
| | 2 | |
| | 2 | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2734 | | Manufactured | No | | | 140 | Each | 107.0000 | 2 | 2 | | 14-04-08 | ** |
| *D2734* Step End Plate | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 107 | |
| | 47 | |
| | 60 | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3560-042 | | Manufactured | No | | | 140 | Each | 0.0000 | 1 | 1 | | 14-04-07 | ** |
| *D3560-042* Arm Weldment | | | | | | | | | | | | | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3560-044 | | Manufactured | No | | | 140 | Each | 1.0000 | 1 | 1 | | 14-04-07 | ** |
| *D3560-044* Arm Weldment | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 1 | |
| | 1 | |

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

| Work Order: _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|---|---|--|---|--|------------------------------------|--|--------------------------------------|-------------|-----------------|--------------|
| | | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| | | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | General | | | Folio/Program | | | Outside Dimensions | | | Pressure/Forced | |
| | <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance | | | <input type="checkbox"/> Set-up | | | | |
| | <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect | | | <input type="checkbox"/> Temperature/Cure | | | | |
| | <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing | | | <input type="checkbox"/> Weld | | | | |
| | <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved | | | <input type="checkbox"/> Wrong Stock Pulled | | | | |
| | <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong | | | <input type="checkbox"/> Other | | | | |
| | <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge | | | | | | | |
| | <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread | | | | | | | | |
| | <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Off-set | | | | | | | | |
| | <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Out of Calibration | | | | | | | | |
| | <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence | | | | | | | | |
| | <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | | | | | | | | | |

Picklist Print

Page 2

April-02-14 10:08:40 AM

Work Order ID: 115476

115476
D3562-042

Parent Item: D3562-042

Parent Item Name: Step Weldment

Start Date: 4/02/14

Required Date: 4/11/14

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W5

Purchased

No

160

Each

344.0000

32

32

*******4/14-04-07****MS20600-AD4W5***

Blind Rivet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST311 | 296 | |
| m127376 | 46 | |
| <u>m128429</u> | 246 | <u>32</u> |
| m128468 | 4 | |
| WA003 | 48 | |
| m125654 | 48 | |

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

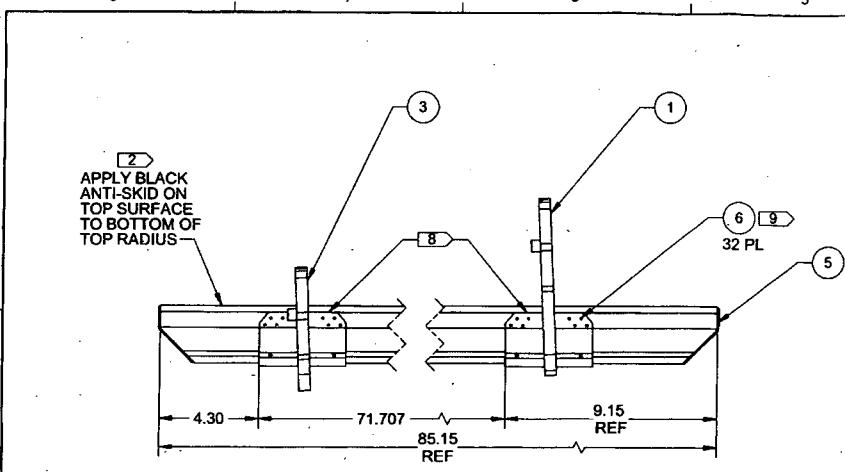
Work Order update only

| | | |
|---|--|---|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> |
|---|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

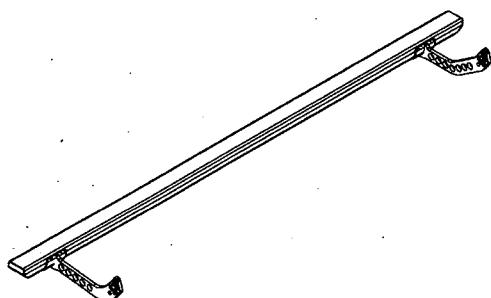
FAULT CATEGORY

| | | | | | | | | | | | | |
|--|--|--------------------------|--------------------------|--------------------------|---|--------------------------|--------------------------|--------------------------|--|--------------------------|--|--------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | | | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

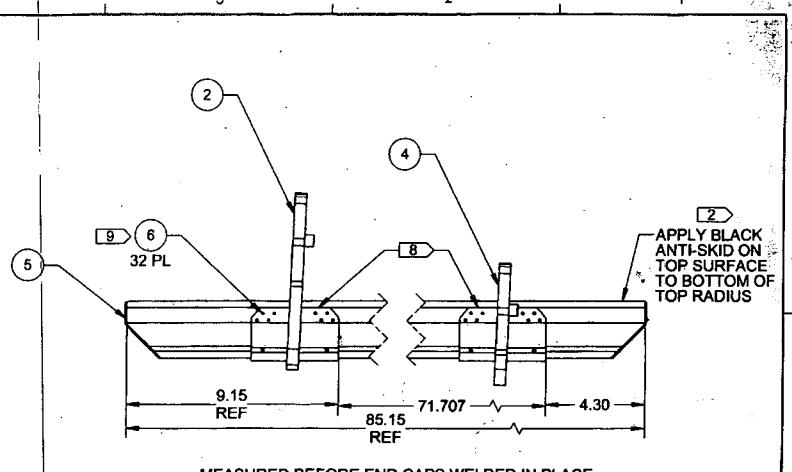


D3562-041 LH STEP ASSEMBLY

NOTES:

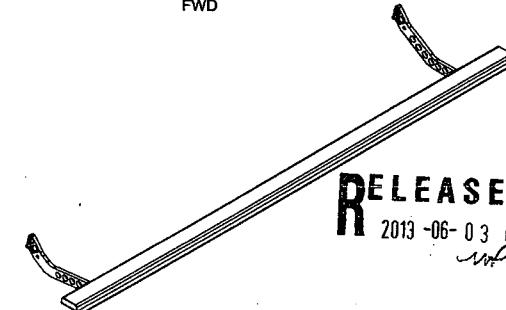
- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANTEX (4.3.5.6) OR
BLACK SANTEX (4.3.5.7) OR
GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

| ITEM No. | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|----------|----------|----------|--------------|------------------|
| | X | | D3562-041 | LH STEP ASSEMBLY |
| | | X | D3562-042 | RH STEP ASSEMBLY |
| 1 | 1 | | D3560-041 | ARM WELDMENT |
| 2 | | 1 | D3560-042 | ARM WELDMENT |
| 3 | 1 | | D3560-043 | ARM WELDMENT |
| 4 | | 1 | D3560-044 | ARM WELDMENT |
| 5 | 1 | 1 | D3562-1 | STEP ASSEMBLY |
| 6 | 32 | 32 | MS20600AD4W5 | RIVET |



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



RELEASED
2013-06-03
m

D3562-042 RH STEP ASSEMBLY

| | | | |
|------------|--|---|--------------|
| F | REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PART 12-224. ADDED NOTE 9 AND SHEET 2 | DW | 13.05.15 |
| E | ADD QTY(2) TO D2734 END PLATE ON D3562-042 | PH | 08.01.11 |
| D | REMOVE D2808 SPACER NOTE: REDRAW IN SOLIDWORKS | DC | 07.11.16 |
| C | NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS | CP | 07.06.19 |
| B | ARMS NOW RIVeted TO STEP | CP | 07.01.15 |
| A | NEW ISSUE | CP | 06.09.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>g</i> | DART AEROSPACE LTD | |
| DRAWN | <i>Dw</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>g</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>g</i> | D3562 | SHEET 1 OF 2 |
| APPROVED | <i>g</i> | TITLE | SCALE |
| DE APPR. | <i>g</i> | STEP ASSEMBLY | NTS |
| DATE | 13.05.15 | COPyRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

DOA:

Date:

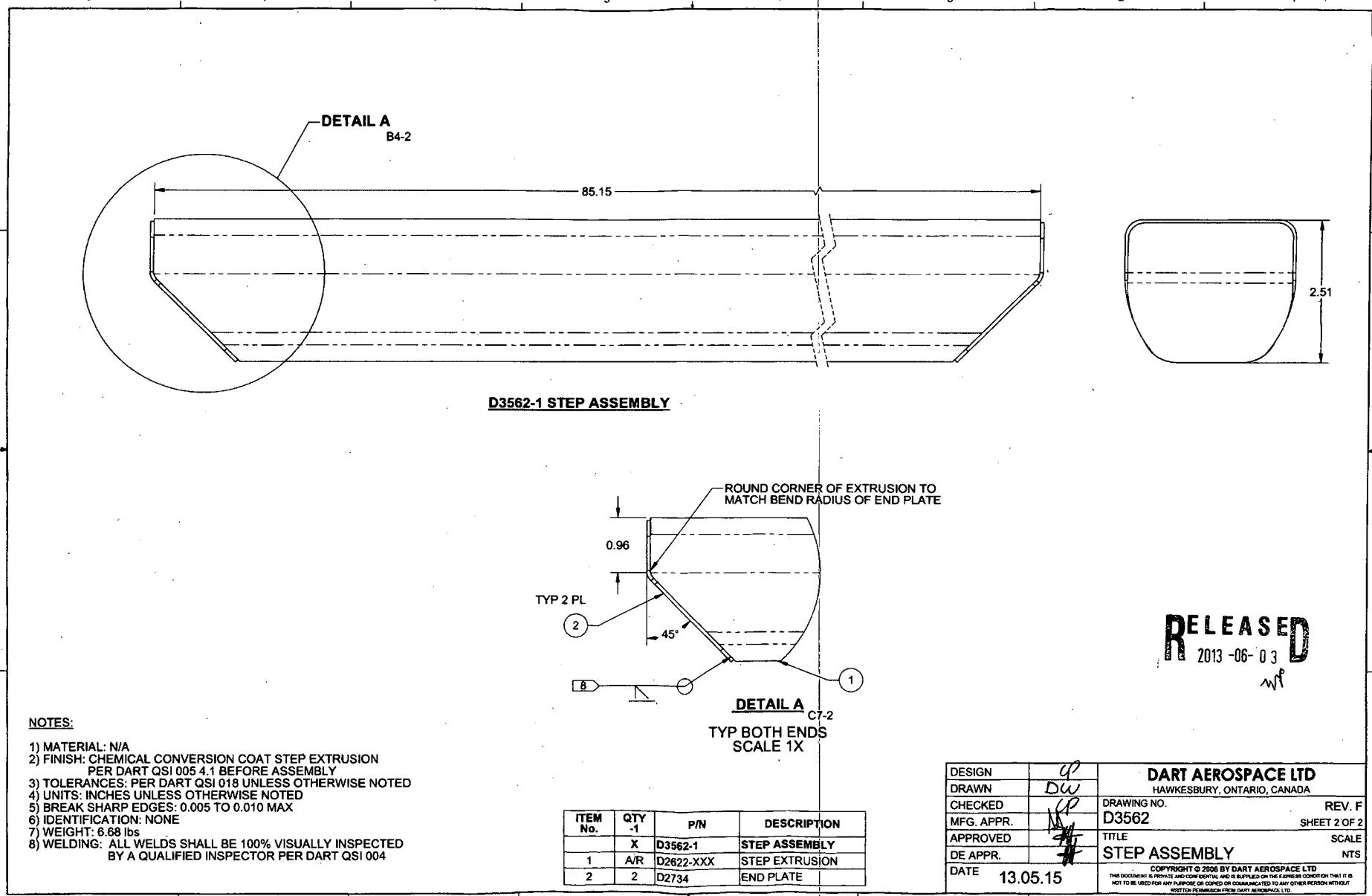


WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed:

Date:

Work Order update only



| | | |
|------------|----------|-----------------------------|
| DESIGN | CP | DART AEROSPACE LTD |
| DRAWN | DW | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | CP | DRAWING NO. REV. F |
| MFG. APPR. | MP | D3562 SHEET 2 OF 2 |
| APPROVED | MP | TITLE |
| DE APPR. | MP | SCALE |
| DATE | 13.05.15 | NTS |

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WRITTEN PERMISSION FROM DART AEROSPACE LTD

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

| | | | | | | | |
|-------------------|---|--|------------------------------------|--|--------------------------------------|--|--|
| Work Order: _____ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | |
| NCR No. _____ | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | |
| | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | |
| | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | | | | | |
|--------------|---|---|--|---|---|--|--|--|--|--|
| Landing Gear | General | | | | | | | | | |
| | <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Pressure/Forced | | | | | |
| | <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Set-up | | | | | |
| | <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect | <input type="checkbox"/> Temperature/Cure | | | | | |
| | <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing | <input type="checkbox"/> Weld | | | | | |
| | <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved | <input type="checkbox"/> Wrong Stock Pulled | | | | | |
| | <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong | <input type="checkbox"/> Other | | | | | |
| | <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge | | | | | | |
| | <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | | | | | | | |
| | <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | | | | | | | |
| | <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | | | | | | | |
| | <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | | | | | | | |